

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023076**Date Inspected:** 25-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint- 019 Located on Crash Barrier E5-SB25A-002. Welder is identified as 206296. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint- 126, Located on Crash Barrier E5-SB24-003. Welder is identified as 201889. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

Weld joint- 081 Located on Crash Barrier E5-SB25-003. Welder is identified as 062092. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

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Shielded Metal Arc Welding (SMAW)

Weld joint- 019 Located on Crash Barrier E5-SB25A-003. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-B-P-2231.

Bay #19

This QA Inspector observed the following work in progress,

Flux Cored Arc Welding (FCAW)

Weld joint- 081, Located on Cable bracket SA6031. Welder is identified as 062807. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint- 084, Located on Cable bracket SA6031. Welder is identified as 062807. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 118, Located on Cable bracket SA6531. Welder is identified as 058792. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint- 125, Located on Cable bracket SA6531. Welder is identified as 062749. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW)

Weld joint- 168, Located on Suspender Bracket SB27-001-110W. Welder is identified as 259566. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-TC-U4B-FCM.

Weld joint- 172, Located on Suspender Bracket SB28-001-110E. Welder is identified as 058792. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-TC-U4B-FCM.

Bay #14

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Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08630

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG Lift 13 components. The weld designations reviewed are as follows:

SP3073-001- Jt. nos -088~099

SEG3009E- Jt. nos -166, 266, 271, 276, 281, 286, 291, 296, 301

SEG3009G- Jt. nos -165, 205, 207, 209, 211, 267, 269, 270, 272, 274, 275, 277, 279, 280, 282, 284, 285, 287,

SEG3009G- Jt. nos- 289, 290, 292, 294, 295, 297, 298, 301, 302, 305, 306, 309, 311, 313

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

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Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
